

**Work Order ID 68959**

*Tuesday, April 26, 2011 12:59:17 PM*



Page 1

Item ID: D3278-2

**Revision ID:**

**Item Name:** Support

**Start Date:** 4/26/2011    **Start Qty:** 40.00

**Required Date:** 4/29/2011      **Req'd Qty:** 40.00

#### **Reference:**

#### **Approvals:**      **Process Plan:**

Date: 11/04/21 Tooling

Date: / / SPC (Y/N)

**Cust Item ID:**

**Customer:**

## Setup Start

Stop

## Run Start

Stop

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 68959**

Tuesday, April 26, 2011 12:59:17 PM



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Item ID: D3278-2

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 4/26/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

SL 11/05/17



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

40 BL 11-5-17.

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

12:00

OVEN TEMPERATURE:

320°

FINISH TIME:

12:30.

40 BL 11-5-17.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**Work Order ID 68959**

Tuesday, April 26, 2011 12:59:17 PM



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Item ID: D3278-2

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 4/26/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC3- Inspect Part Finish

0.00

X6

40

6

Mulosha

QC

Quality Control

170

Identify as per dwg & Stock Location Small fab

0.00

11/5/17

SF (43)

Packaging

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

11/5/18 JJ

QC

Quality Control

ME  
11-05-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Tuesday, April 26, 2011 12:59:24 PM

Page 1

Work Order ID: 68959



Parent Item: D3278-2



Parent Item Name: Support

Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP:  A  04.04.19  New issue  KJ/JLM  
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	52.4300	0.2337	9.84			

6061-T6 Bar 1.00 x 2.00



Location	Loc Qty	Loc Code
MAT004	52.43	
112567	22.6	
114415	0.87	
115045	5.6	
116623	3.36	
✓ 117379	20	

9.8400 ft B.A 11/05/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68959
Description: Support	"	Part Number:	D3278-2
Inspection Dwg: D3278	Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø 0.100	✓		Vern	GA-01
0.359	+/-0.005	0.357	✓		"	"
0.609	+/-0.010	0.610	✓		"	"
0.250	+/-0.010	0.247	✓		"	"
1.480	+/-0.005	1.480	✓		"	"
R0.125	+/-0.010	R0.125	✓		R-G	ref.
0.119	+0.005/-0.004	0.120	✓		Vern	GA-01
2.439	+/-0.010	2.440	✓		"	"
1.980	+/-0.010	1.981	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-G	ref.
Ø0.257	+0.005/-0.000	Ø0.259	✓		Vern	GA-01
R0.375	+/-0.010	R0.375	✓		R-G	ref.
0.875	+/-0.010	0.875	✓		Vern	GA-01
0.500	+/-0.010	0.502	✓		H-G	31006
R0.400	+/-0.010	R0.400	✓		R-G	ref.
R1.00	+/-0.030	R1.000	✓		"	"
1.720	+/-0.010	1.720	✓		Vern	GA-01
R0.125	+/-0.010	R0.125	✓		R-G	ref.
0.125	+/-0.010	0.125	✓		Vern	GA-01

Measured by:	K.A	Audited by:	SL	Prototype Approval:	N/A
Date:	11/05/16	Date:	11/05/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	EZ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

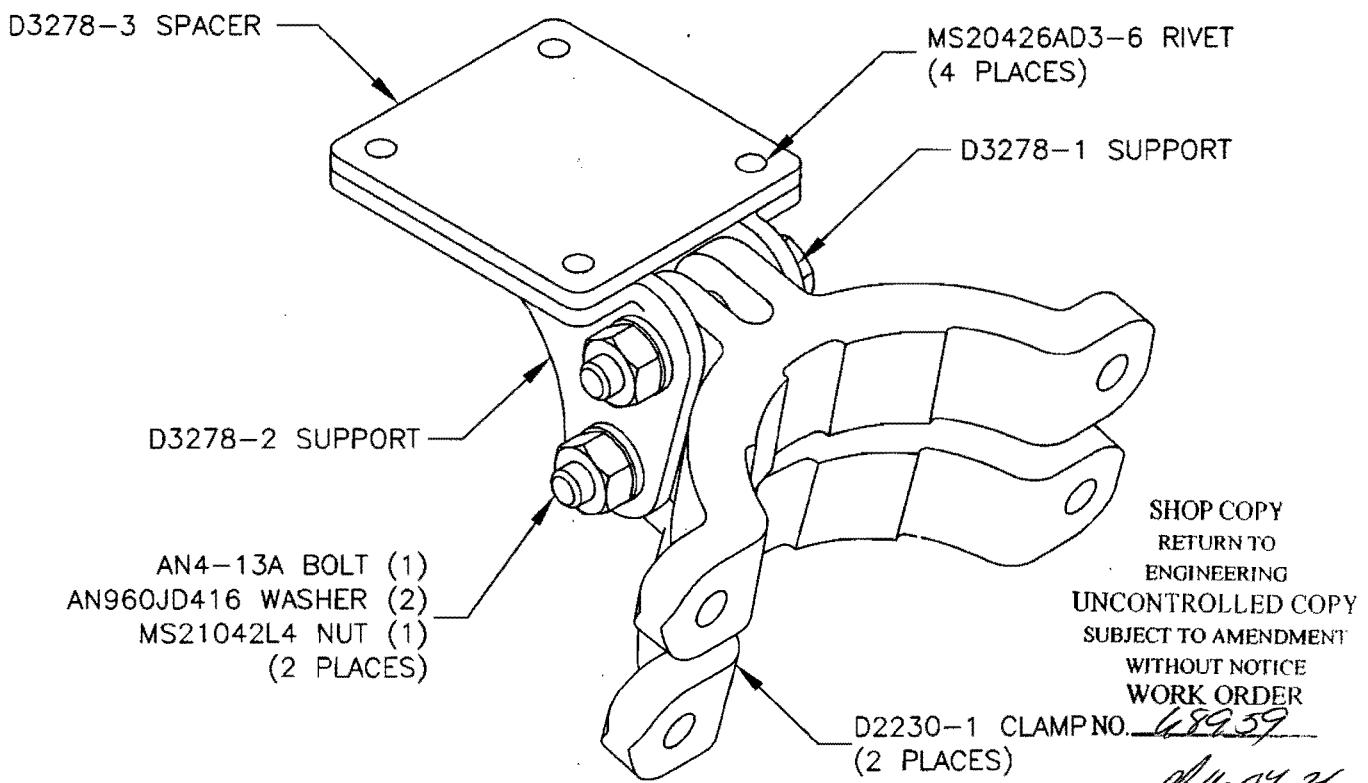
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>JL</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
07.08.06D3278-041 SUPPORT ASSEMBLY

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

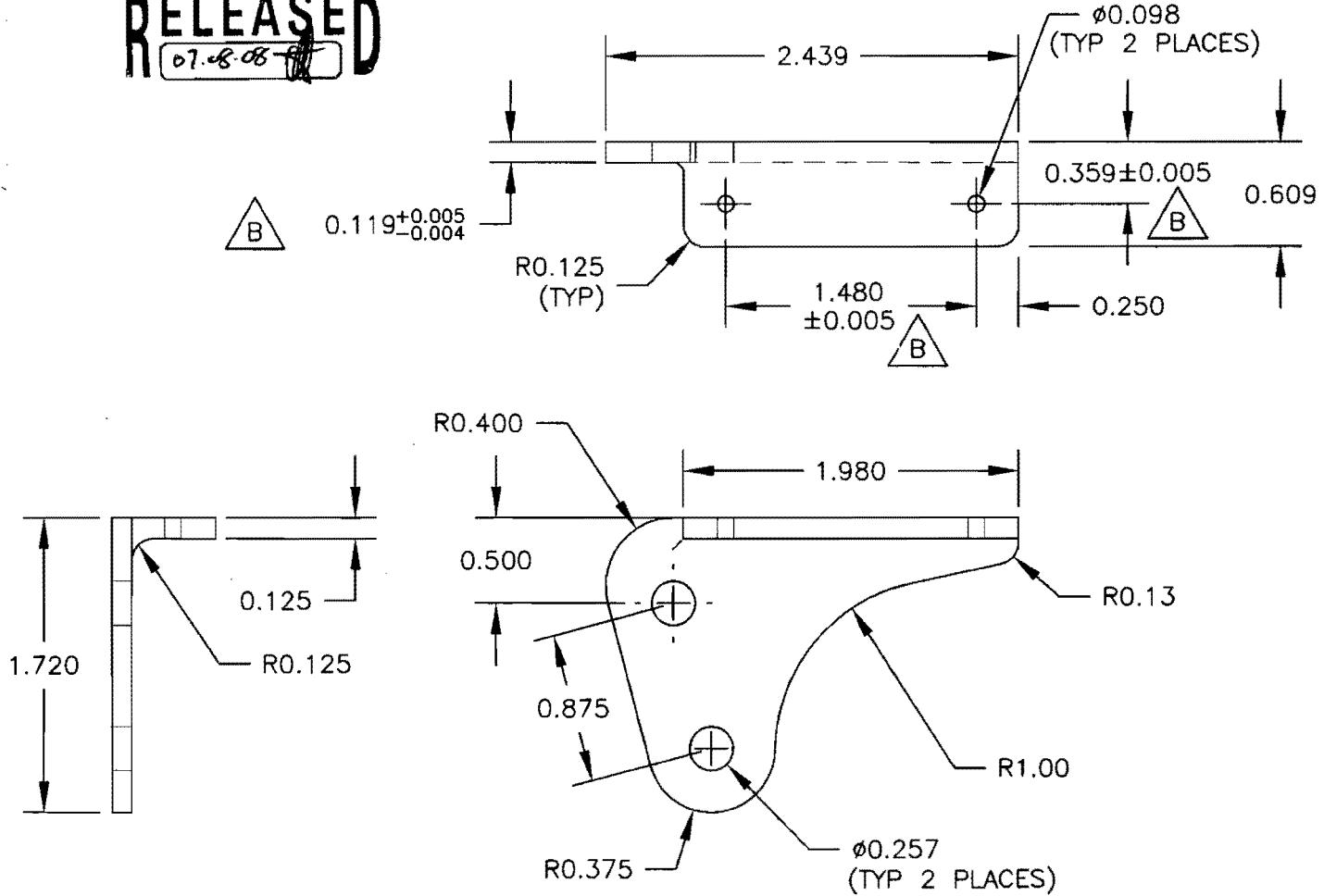
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>BS</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3	
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1	

**RELEASED**  
07-08-08

D3278-1 SUPPORT (SHOWN)  
D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"  
2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)  
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POUDÉR COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
4) BREAK ALL SHARP EDGES 0.005 TO 0.015  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

*WJ 68959*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

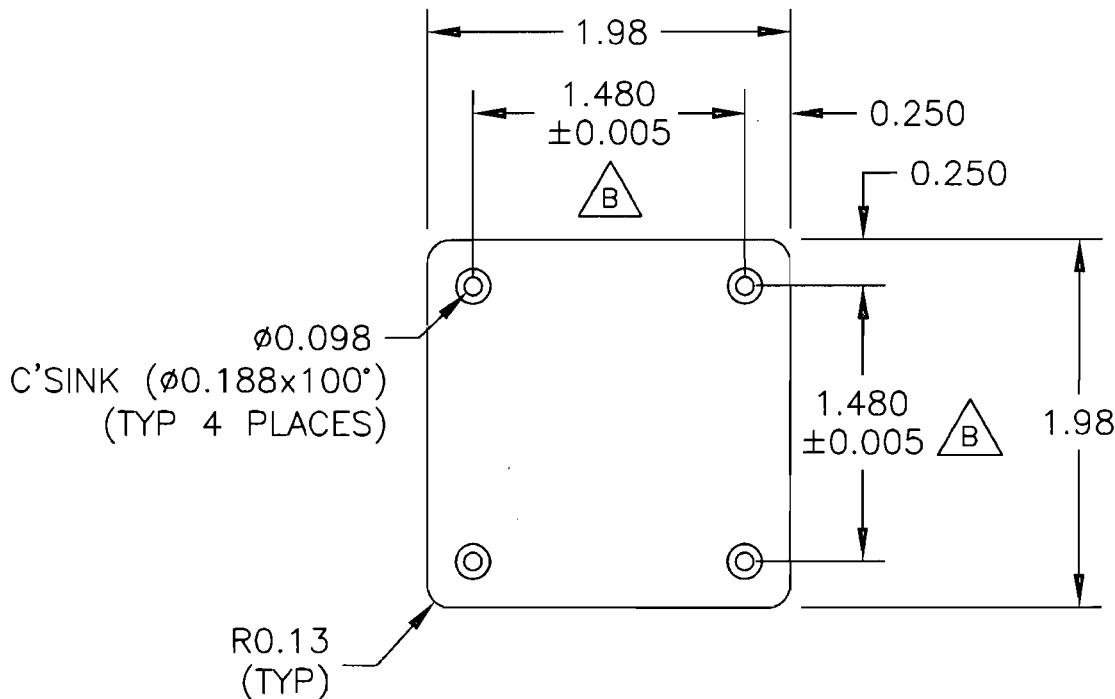
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>JB</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3	
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1	

**RELEASED**  
07.08.08*6/6 68933***D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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